

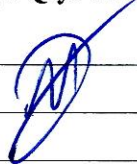
Work Order ID 156617

Thursday, February 02, 2017 3:43:27 PM

156617

Page 1

Item ID: D3915-041 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Light Lid Assembly, Long Basket
Start Date: 3/13/2017 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 3/15/2017 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan:  Date: FEB 02 2017 Tooling: Date: Run Start ***NR1***
QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3915	E								

100 Weld per dwg A/R Aluminum rod Batch: **B131562**
Large Fab

100

Large Fab

Large Fab

Memo

0.38

1- assemble ribs , weld as per dwg D3915 using DT9606A. When welding D4019-3, weld top and bottom then make a small hole in the weld to let air out. Then weld remaining sides of D4019-3 Rib. Let it cool down, then block holes with weld.

****DO NOT WELD THE (4) CORNERS. GRIND OFF CORNERS TO HAVE A 1/8" GAP TO GET THE ACID AND ALODINE OUT OF BASKET LID FRAME****

2- weld hinge, label plate and Mounting plates as per dwg D3915

1x CC 17-3-14

110

QC9- Inspect visual per QSI004- Fusion Welds 0.00

110

QC

Quality Control

Memo

0.00

D 17-03-17 PD 9 9-89

Work Order ID 156617

Thursday, February 02, 2017 3:43:27 PM

156617

Page 2

Item ID: D3915-041 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Light Lid Assembly, Long Basket
Start Date: 3/13/2017 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 3/15/2017 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC5- Inspect part completeness to step on W/O	0.00							
120									
QC	Memo	0.00							
Quality Control									
130	Chemical Conversion Coat per QSI005 4.1	0.00							
130									
HandFinish	Memo	0.15							
Hand Finishing	***ENSURE TO RINSE CAREFULLY ACID AND ALODINE***								
140	Weld per dwg A/R Aluminum rod Batch: 2131562	0.00							
140									
Large Fab	Memo	0.09							
Large Fab	1- weld (4) corners								

DAS
9
9-89

(x1)  2017/03/21
BEB,

4x CC 17-3-21

Work Order ID 156617

Thursday, February 02, 2017 3:43:27 PM

156617

Page 3

Item ID: D3915-041 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Light Lid Assembly, Long Basket
Start Date: 3/13/2017 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 3/15/2017 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	QC9- Inspect visual per QSI004- Fusion Welds	0.00							
150									
QC	Memo	0.00							DAS 9 9-89
Quality Control									
155	QC6- Inspect dimensions to drawing	0.00							
155									
QC	Memo	0.00							DAS 9 9-89
Quality Control	***inspect fit of lid with base***								
157	Chemical Conversion Coat per QSI005 4.1	0.00							
157									
HandFinish	Memo	0.14							
Hand Finishing	1- realodine corners ***do not acid etch***								(x1) 201703122 BEB

Work Order ID 156617

Thursday, February 02, 2017 3:43:27 PM

156617

Page 4

Item ID: D3915-041 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Light Lid Assembly, Long Basket
 Start Date: 3/13/2017 Start Qty: 1.00 *1* Cust Item ID:
 Required Date: 3/15/2017 Req'd Qty: 1.00 *1* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00				1	0	17-03-22	34 33
160	<i>M 136657</i>								
Powdercoat	Memo	0.03							
Powder Coating	1- touch up corner with alodine only 2- Plug holes prior to								
	1ST COAT: <i>11:15</i> START TIME: <i>11:45</i> OVEN TEMPERATURE: <i>320°</i> FINISH TIME: <i>11:45</i> ***** 2nd coat if necessary*****								
	2ND COAT: START TIME: _____ OVEN TEMPERATURE: _____ FINISH TIME: _____								
170	QC3- Inspect Part Finish	0.00							
170									
QC	Memo	0.00							
Quality Control									

DAS
15
9-89

Work Order ID 156617

Thursday, February 02, 2017 3:43:27 PM

156617

Page 5

Item ID: D3915-041 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Light Lid Assembly, Long Basket
Start Date: 3/13/2017 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 3/15/2017 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	Assemble as per dwg	0.00							
180									
HandFinish	Memo	0.19							
Hand Finishing	1- Install webbing as per dwg								
	2- Install placard and label as per dwg								
190	QC5- Inspect part completeness to step on W/O	0.00							
190									
QC	Memo	0.00							
Quality Control									
200	Identify as per dwg & Stock Location: <u>wb</u>	0.00							
200									
Packaging	Memo	0.00							
Packaging									

DAS
33
9-89

MAR 23 2017

Work Order ID 156617

Thursday, February 02, 2017 3:43:27 PM

156617

Page 6

Item ID: D3915-041 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Light Lid Assembly, Long Basket
Start Date: 3/13/2017 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 3/15/2017 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
210	QC21- Final Inspection - Work Order Release	0.00							
210									
QC	Memo	0.02							
Quality Control									

 MAR 24 2017

Picklist Print

Thursday, February 02, 2017 3:43:58 PM

Page 1

Work Order ID: 156617

156617

Parent Item: D3915-041

D3915-041

Parent Item Name: Light Lid Assembly, Long Basket

Start Date: 3/13/2017

Required Date: 3/15/2017

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A new issue DD 10.03.19 verified by:EC IPP Rev:B as per dwg revB DD 10.04.20 verified by:EC IPP Rev:C add realodine DD 10.04.26 verified by:EC IPP Rev:D as per dwg revC DD 10.08.18 verified by:EC IPP Rev:E 13.07.08 as per dwg rev.D DD verf:JLM IPP REV:D 13.08.21 DWG REV.E / ECN 13-624 DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
✓ D2957 *D2957* Mounting Plate		Manufactured	No			100	Each	21.0000	4	4			
					<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>						
					WA004	21							
					138993	21							
✓ D3915-1 *D3915-1* Rib		Manufactured	No			100	Each	4.0000	2	2			
					<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>						
					WA004	4	B157459						
					151022	4							
✓ D4016-5 *D4016-5* Hinge Half, Light Lid		Manufactured	No			100	Each	39.0000	3	3			
					<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>						
					WA004	39							
					137225	7							
					152120	32							

Picklist Print

Thursday, February 02, 2017 3:43:58 PM

Work Order ID: 156617

156617

Parent Item: D3915-041

D3915-041

Parent Item Name: Light Lid Assembly, Long Basket

Start Date: 3/13/2017

Required Date: 3/15/2017

Start Qty: 1.00

Required Qty: 1.00

D4019-3

Manufactured No

100 Each 7.0000 3 3

D4019-3

**

Rib

LocationLoc QtyLoc Code

WA004

7

1

6

144402

154037

B157528

3x

D4035-047

Manufactured No

100 Each 0.0000 2 2

D4035-047

Lid Rib Assembly, Aft (Light)

B157748

**

D4056-1

Manufactured No

100 Each 5.0000 1 1

D4056-1

**

Label Plate

LocationLoc QtyLoc Code

WA004

5

5

120216

D2728-1

Manufactured Yes

180 Each 0.0000 1 1

D2728-1

Dart Logo Label Small

**

D4029-041

Manufactured No

180 Each 1.0000 1 1

D4029-041

**

Webbing (Long Basket)

LocationLoc QtyLoc Code

ST498A

1

149654

1

Picklist Print

Thursday, February 02, 2017 3:43:58 PM

Page 3

Work Order ID: 156617

156617

Parent Item: D3915-041

D3915-041

Parent Item Name: Light Lid Assembly, Long Basket

Start Date: 3/13/2017

Required Date: 3/15/2017

Start Qty: 1.00

Required Qty: 1.00

MS20600-AD4W4

Purchased

No

180

Each

1,073.000

34

34

MS20600-AD4W4

Rivet

DAS
6
9-89

MAR 22 2017

Location

Loc Qty

Loc Code

CCK004

11

M135704

11

ST308

74

M133990

74

WA003

988

M135442

204

M136295

784

137025

NAS1149DN949J

Purchased

No

180

Each

126.0000

34

34

NAS1149DN949J

Washer

DAS
6
9-89

m136781 x 16

MAR 22 2017

Location

Loc Qty

Loc Code

ST265

126

m135058

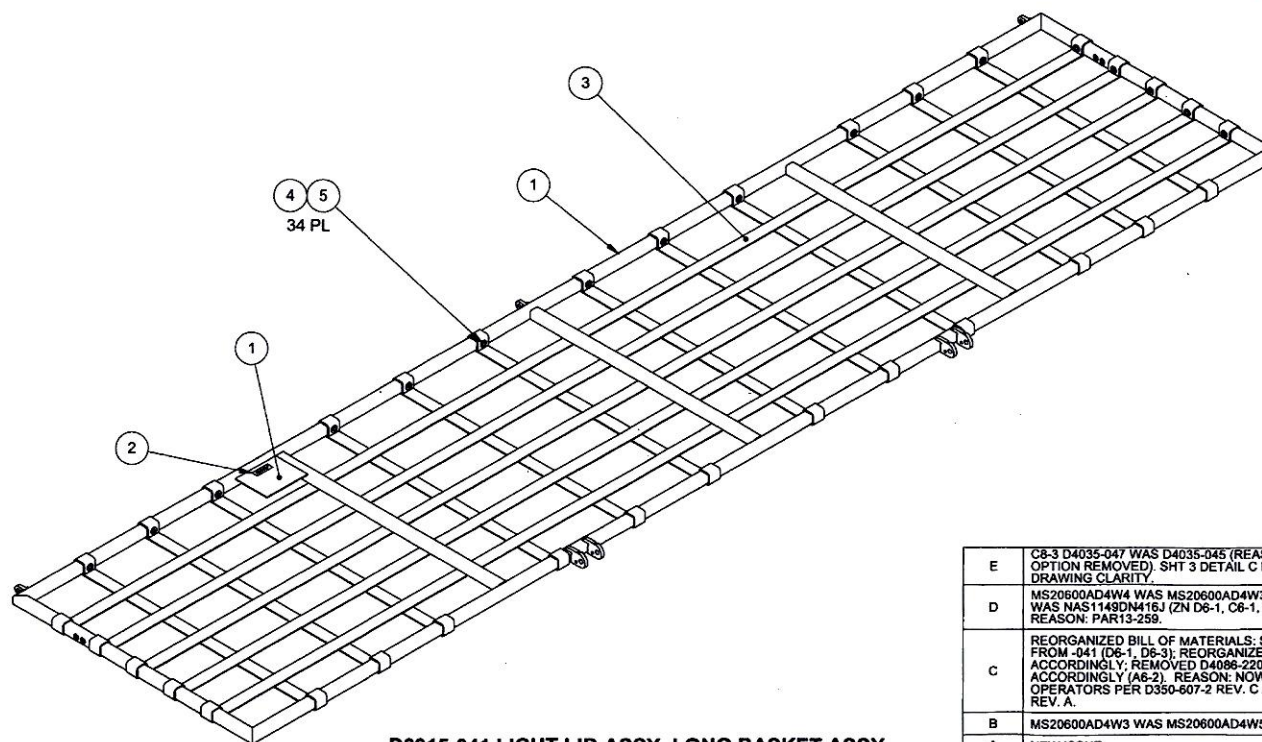
126

28

ITEM	QTY -041	P/N	DESCRIPTION
	X	D3915-041	LIGHT LID ASSY, LONG BASKET ASSY
1	1	D3915-101	BASKET LID WELDMENT ASSY
2	1	D2728-1	DART LOGO LABEL
3	1	D4029-041	WEBBING (LONG BASKET)
4	34	NAS1149DN949J	WASHER
5	34	MS20600AD4W4	RIVET, BLIND, PAN-HEAD

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *156617*

FEB 02 2017



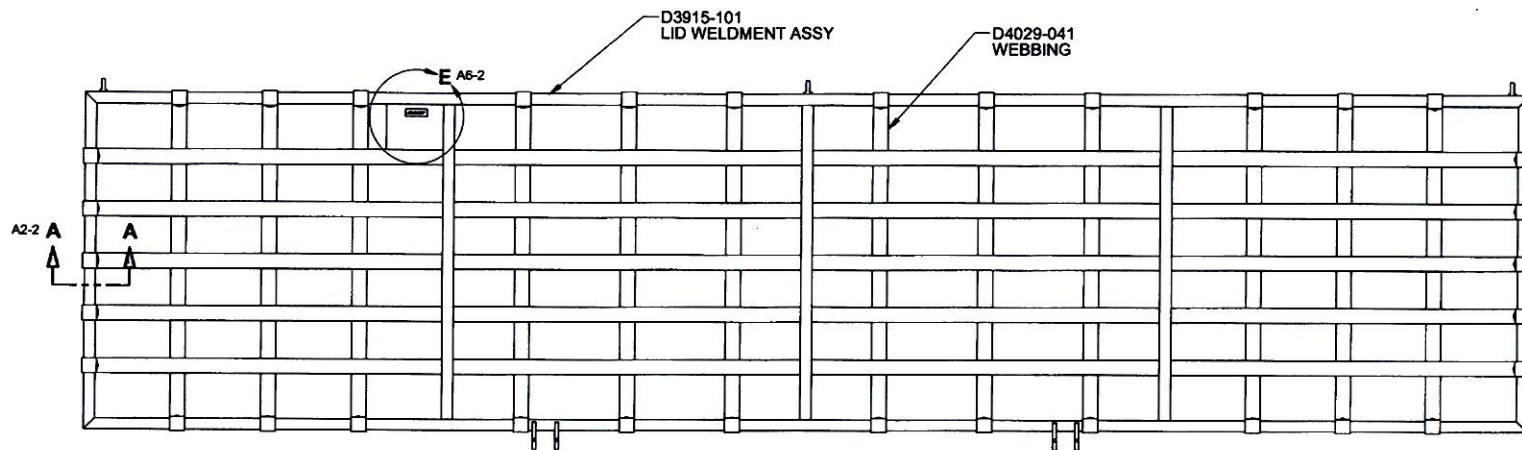
D3915-041 LIGHT LID ASSY, LONG BASKET ASSY

RELEASED
2013-08-16

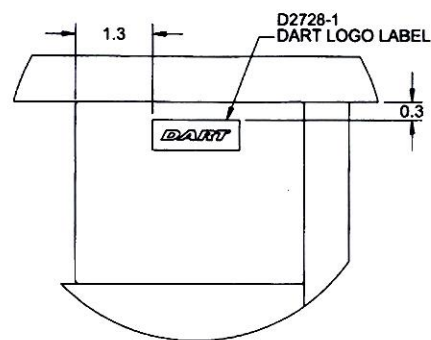
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 6.98 lbs

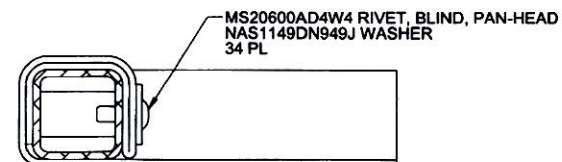
E	C8-3 D4035-047 WAS D4035-045 (REASON PROPPARM OPTION REMOVED). SHT 3 DETAIL C DELETED FOR DRAWING CLARITY.	AJS	13.07.18
D	MS20600AD4W4 WAS MS20600AD4W3; NAS1149DN949J WAS NAS1149DN416J (ZN D6-1, C6-1, B1-2). REASON: PAR13-259.	MB	13.06.19
C	REORGANIZED BILL OF MATERIALS; SEPARATED -101 FROM -041 (D6-1, D6-3); REORGANIZED VIEWS ON SHT 3 ACCORDINGLY; REMOVED D4086-220, UPDATED VIEW E ACCORDINGLY (A6-2). REASON: NOW INSTALLED BY OPERATORS PER D350-607-2 REV. C AND D350-607-3 REV. A.	MB	10.08.05
B	MS20600AD4W3 WAS MS20600AD4W5: BOM & (B1-2)	JPH	10.04.06
A	NEW ISSUE	JPH	10.03.16
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3915 TITLE LIGHT LID ASSY-LONG BASKET SCALE Nts COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	
DRAWN	AJS		
CHECKED	<i>[Signature]</i>		
MFG. APPR.	<i>[Signature]</i>		
APPROVED	<i>[Signature]</i>		
DE APPR.	<i>[Signature]</i>	REV. E SHEET 1 OF 4	
DATE	13.07.18		



D3915-041 LIGHT LID ASSY, LONG BASKET



DETAIL E D6-2



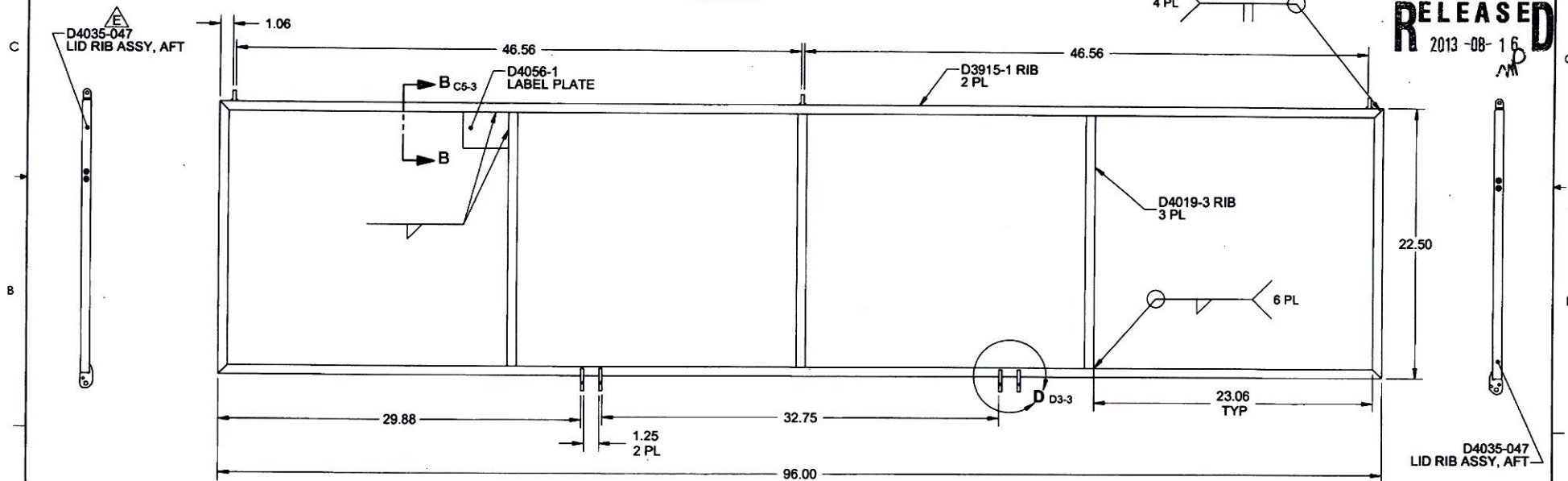
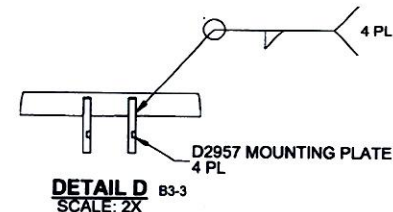
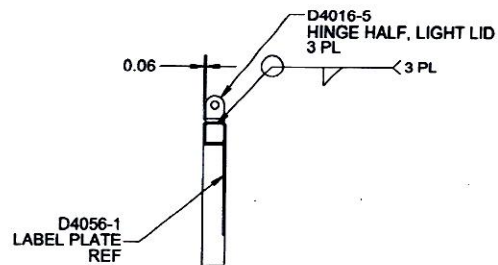
SECTION A-A C8-2
SCALE: 8X

RELEASED
2013-08-16

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. E
MFG. APPR.	<i>[Signature]</i>	D3915	SHEET 2 OF 4
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	LIGHT LID ASSY-LONG BASKET NTS	
DATE	13.07.18	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

SHEET 2 OF 4

ITEM	QTY	P/N	DESCRIPTION
	X	D3915-101	BASKET LID WELDMENT ASSY
1	2	D3915-1	RIB
2	4	D2957	MOUNTING PLATE
3	3	D4016-5	HINGE HALF, LIGHT LID
4	3	D4019-3	RIB
5	2	D4035-047	BASKET LID RIB ASSY, AFT (LIGHT)
6	1	D4056-1	LABEL PLATE, 350 LIGHT BASKET



RELEASED
2013-08-16

D3915-101 BASKET LID WELDMENT ASSY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 4.82 lbs
- 8) WELD PER DART QSI 004

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	[Signature]	DRAWING NO. D3915	REV. E
MFG. APPR.	[Signature]	SHEET 3 OF 4	
APPROVED	[Signature]	TITLE LIGHT LID ASSY-LONG BASKET	SCALE Nts
DE APPR.	[Signature]	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
DATE	13.07.18	THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMERCIALIZED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

